

67343 AIR MOTOR ALSO COVERS 637399 SERVICE KIT



**READ THIS MANUAL CAREFULLY BEFORE INSTALLING,
OPERATING OR SERVICING THIS EQUIPMENT.**

It is the responsibility of the employer to place this information in the hands of the operator. Keep for future reference.

AIR MOTOR DISASSEMBLY

NOTE: All threads are right hand. Carefully remove the parts, inspect for damage, nicks or excessive wear and determine if any parts will need replacement.

1. Using a 7/8" wrench, unthread and remove (11) adapter and (12 and 13) "O" rings, releasing (14) muffler housing.
2. Using a 3/8" wrench, unthread (28) tie rods and remove (27) plate.
3. Remove four (1) bolts, (2) upper cap and (3) track gasket.
4. Remove (10) cylinder, containing (4) sleeves and (7) spools.
5. Using (1) bolt, push (7) spools and (4) sleeves out "sleeve" end of (10) cylinder.
6. Remove (16) retaining ring, (17) washer and (19) piston.
7. Remove (22) dowel pin, releasing (20) piston adapter.
8. Remove (3) track gasket and (23) lower cap.
9. Remove (26) adapter, with (24) "O" ring and (25) "U" cup.

AIR MOTOR REASSEMBLY

NOTE: Thoroughly clean and lubricate all seals. Replace all soft parts with new ones included in the repair kit. Note: Refer to the illustration (figure 2, page 2) for "U" cup lip seal direction.

1. Assemble (24) "O" ring and (25) "U" cup to (26) adapter and assemble to (23) lower cap.
2. Assemble (29) piston rod up thru (26) adapter.
3. Assemble (3) track gasket to (23) lower cap.
4. Assemble (21) "O" ring to (20) piston adapter and assemble (20) piston adapter to (29) piston rod, securing with (22) dowel pin.
5. Replace (18) "U" cups on (19) piston and assemble (19) piston onto (20) piston adapter, securing with (17) washer and (16) retaining ring.
6. Replace (5) "O" rings on (4) sleeves and assemble (4) sleeves into (10) cylinder. NOTE: Assemble each sleeve into the end of the cylinder nearest the exhaust hole.
7. Replace (6 and 9) "O" rings and (8) "U" cups on (7) spools and assemble (7) spools into (10) cylinder from the opposite end as the (4) sleeve went in.
8. Assemble (10) cylinder to (23) lower cap, being careful when sliding over the lips of (18) "U" cups. NOTE: Be sure (3) track gasket is seated properly.

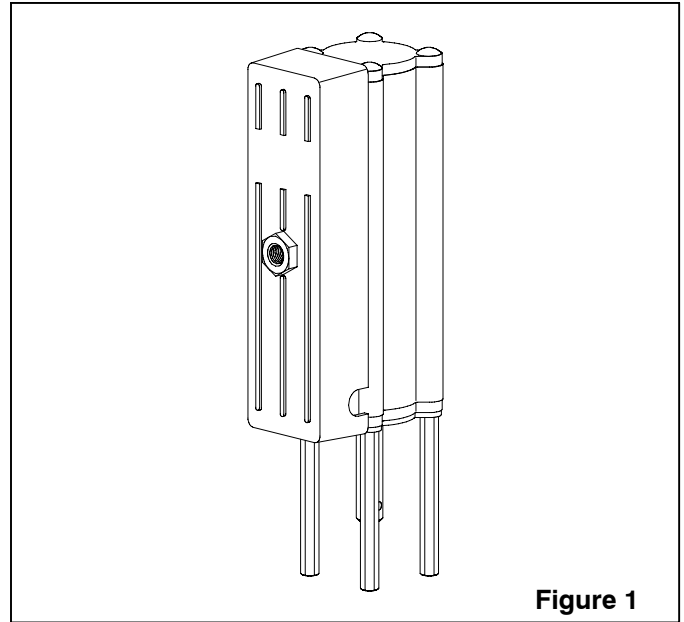


Figure 1

9. Replace (3) track gasket on (2) upper cap and assemble (2) upper cap to (10) cylinder.
10. Assemble (1) bolts to air motor.
11. Assemble (27) plate to air motor, securing with (28) tie rods. NOTE: Tighten tie rods to 80 - 90 in. lbs (9.0 - 10.2 Nm).
12. Replace (12 and 13) "O" rings on (11) adapter.
13. Assemble (15) foam liners to (14) muffler housing.
14. Assemble (14) muffler housing to (10) cylinder, securing with (11) adapter. NOTE: Torque (11) adapter to 80 in. lbs (9.0 Nm) maximum.

TROUBLE SHOOTING

If the pump will not cycle or will not deliver material.

- Be certain to check for non-pump problems including kinked, restrictive or plugged inlet / outlet hose or dispensing device. Depressurize the pump system and clean out any obstructions in the inlet / outlet material lines.
- Check all seals, including track gaskets.
- Check the direction of "U" cup lips.

PARTS LIST

Item	Description (size)	Qty	Part No.	Mtl
1	Carriage Bolt (1/4" - 20 x 9")	(4)	94333	[C]
2	Upper Cap	(1)	94307	[Z]
✓ 3	Track Gasket	(2)	94311	[B]
4	Sleeve	(2)	94316	[Br]
✓ 5	"O" Ring (1/16" x 11/16" o.d.)	(4)	Y325-15	[B]
✓ 6	"O" Ring (1/8" x 3/4" o.d.)	(4)	Y325-206	[B]
7	Spool	(2)	94310	[D]
✓ 8	"U" Cup (1/8" x 3/4" o.d.)	(2)	Y240-7	[B]
✓ 9	"O" Ring (0.106" x 0.587" o.d.)	(2)	15066-PM	[B]
10	Cylinder	(1)	94249	[A]
11	Adapter	(1)	94447	[C]
✓ 12	"O" Ring (1/16" x 3/4" o.d.)	(1)	Y325-16	[B]
✓ 13	"O" Ring (1/16" x 7/16" o.d.)	(1)	Y325-11	[B]
14	Muffler Housing	(1)	95086	[A]
15	Foam Liner	(2)	94402	
16	Retaining Ring	(1)	94406	[C]
17	Washer	(1)	94515	[C]
✓ 18	"U" Cup (3/16" x 2" o.d.)	(2)	Y240-23	[B]
19	Piston	(1)	94780	[D]
20	Piston Adapter	(1)	95802	[C]
✓ 21	"O" Ring (3/32" x 1" o.d.)	(1)	Y325-117	[B]
22	Dowel Pin (3/16" o.d. x 7/8" long)	(1)	95803	[C]
23	Lower Cap	(1)	94308	[Z]
✓ 24	"O" Ring (1/8" x 1-3/8" o.d.)	(1)	Y325-216	[B]
✓ 25	"U" Cup (1/8" x 7/8" o.d.)	(1)	Y240-9	[B]
26	Adapter	(1)	96062	[A]
27	Plate	(1)	96068	[C]
28	Tie Rod	(4)	96067	[C]
29	Piston Rod	(1)	96066	[C]
✓	Gadus S2 U1000 Grease Packet	(1)	94833	
✓	Items included in Service Kit		637399	

TORQUE REQUIREMENTS

(11) adapter, 80 in. lbs (9.0 Nm) maximum.
(28) tie rods, 80 - 90 in. lbs (9.0 - 10.2 Nm).

LUBRICATION / SEALANTS

Apply Shell Gadus S2 U1000 grease (94833) to all "O" rings, "U" cups and mating parts.

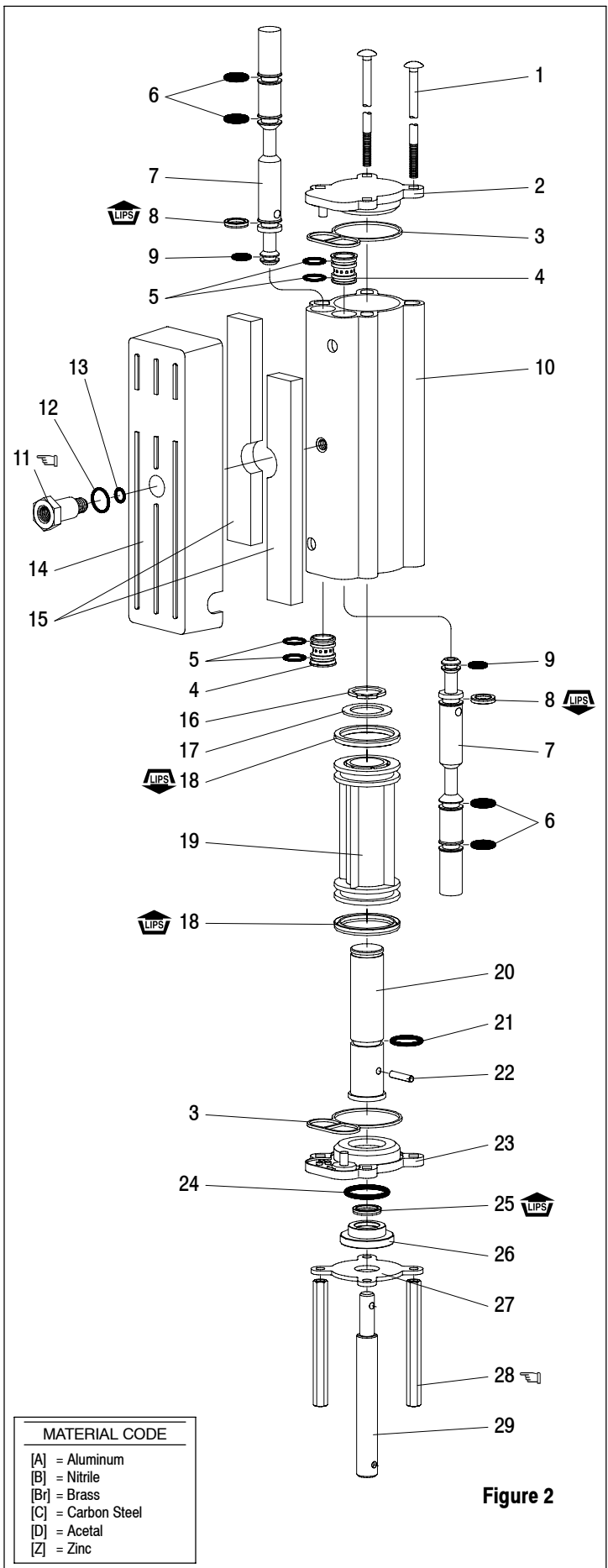


Figure 2

MATERIAL CODE

[A] = Aluminum
[B] = Nitrile
[Br] = Brass
[C] = Carbon Steel
[D] = Acetal
[Z] = Zinc